

Work Order ID 86341

June-27-12 3:19:28 PM

86341

Page 1

Item ID: D206-559-023

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Bearpaw

Start Date: 27/06/2012 Start Qty: 2.00

2

Cust Item ID:

Required Date: 11/07/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/06/28

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN-D206-559	rev L								
100		0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Document Control	Photocopy bluefile and create labels per PPP D206-559-023	CHG007							
160	Pick Kit	0.00							
160									
Packaging	Memo	0.00							
Packaging									
170	QC4- 100% Inspect kits for completeness	0.00							
170									
QC	Memo	0.00							
Quality Control									

DAS 16 9-80 12/06/16

MLJ 12-7-16

sp

2 12/07/17 JB

DAS 16 9-80 12/04/18

72

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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N900040100Setup Start ***NS1***

Revision ID:

Item Name: Bearpaw

Stop ***NS2***

Start Date: 27/06/2012 Start Qty: 2.00

2

Cust Item ID:

Required Date: 11/07/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

0.00

180

Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPPD206-559-023 Location: **F6013**

190

0.00

190

QC21- Final Inspection - Work Order Release

QC

Memo

0.00

Quality Control

12/7/18**12/7/18****ME**
12-07-18

W/O:		WORK ORDER CHANGES					
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Picklist Print

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Work Order ID: 86341

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Parent Item: D206-559-023

D206-559-023

Parent Item Name: Bearpaw

Start Date: 27/06/2012

Required Date: 11/07/2012

Start Qty: 2.00

Required Qty: 2.00

Comments:

IPP Rev: E04.02.17Tolerance added to Step 3KJ/JLM
 IPP Rev: F 07-01-02 Was K10006 JLM
 IPP Rev:G 08-09-19 Added step 2 JLM Verified By:EC
 IPP Rev:H New Manufacturing Method 08-10-29 JLM Verified By:EC
 IPP Rev J 10.10.04 per DSI9527 EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN4-17A

Purchased

No

160

Each

562.0000

12

24

✓

AN4-17A
Bolt

**

JB

✓

Location

Loc Qty

Loc Code

ST358

300

116704

0

121541

300

121541

ST359

262

112314

0

121011

200

121068

62

AN4-20A

Purchased

No

160

Each

505.0000

12

24

✓

AN4-20A
Bolt

**

JB

12/07/17

✓

Location

Loc Qty

Loc Code

GA

50

116419

50

ST359

455

117514

51

121060

104

121541

300

121541

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 86341

Parent Item: D206-559-023

Parent Item Name: Bearpaw

86341

D206-559-023

Start Date: 27/06/2012

Required Date: 11/07/2012

Start Qty: 2.00

Required Qty: 2.00

AN960JD416 NAS1149D0463J Purchased

No

160

Each

31.0000

24

48

AN960JD416

Washer

**

121912 JB

Location

Loc Qty

Loc Code

ST351

31

116289

10

119097

21

D2182B

Manufactured

No

160

f

122.8682

2.5

5

D2182B

Rubber Cushion

**

86201 JB

Location

Loc Qty

Loc Code

ST410

122.86817

63413

1.6

66063

41.61817

73932

79.65

(D2182B050) cut qty (6) at 5.00" as per dwg ***per kit***

D2274

Manufactured

No

160

Each

759.0000

12

24

D2274

Radius Block

**

JB 12/07/17

Location

Loc Qty

Loc Code

ST007

759

78233

2

81958

96

83258

210

84199

251

85455

200

85455

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 86341

Parent Item: D206-559-023

Parent Item Name: Bearpaw

86341

D206-559-023

Start Date: 27/06/2012

Required Date: 11/07/2012

Start Qty: 2.00

Required Qty: 2.00

D2438

Manufactured No

160 Each

142.0000

6

12

**

86341 JB



D2438

Clamp

Location

Loc Qty

Loc Code

ST456

142

77038

6

83265

28

83266

50

84804

58

D2529

Manufactured No

160 Each

761.0000

12

24

**

JB



D2529

Washer

Location

Loc Qty

Loc Code

ST010

761

79485

18

81873

243

84435

500

D2672

Manufactured No

160 Each

1.0000

2

4

**

84435

86341 JB



D2672

Bearpaw 13" X 24", 206

Location

Loc Qty

Loc Code

ST495

1

73110

1

D2732

Manufactured No

160

f

510.0000

2.5

5

**

JB

12/07/17



D2732

Rubber Extrusion

Location

Loc Qty

Loc Code

ST410

510

70987

14

83560

496

83560

(D2732-050) cut qty (6) at 5.00" as per dwg ***per kit***

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Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 86341

Parent Item: D206-559-023

Parent Item Name: Bearpaw

86341

D206-559-023

Start Date: 27/06/2012

Required Date: 11/07/2012

Start Qty: 2.00

Required Qty: 2.00

MS21042L4

Purchased

No

160

Each

1,920.000

12

24

**

JB

12/07/12

MS21042L4

Nut

Location

Loc Qty

Loc Code

ST300

1920

119075

116

121011

193

121444

1311

121652

300

121444

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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5.0 PARTS LIST

Qty -011	Qty -013	Qty -021	Qty -023	Qty -031	Qty -033	Qty -113	Part Number	Description
X							D206-559-011	Bearpaw Kit 206 A/B
	X						D206-559-013	Bearpaw Kit 206 L/L1/L3/L4/407
		X					D206-559-021	Narrow Bearpaw Kit 206 A/B
			X				D206-559-023	Narrow Bearpaw Kit 206 L/L1/L3/L4/407
				X			D206-559-031	Wearplate Kit
					X		D206-559-033	Wearplate Kit
						X	D407-559-113	Large Bearpaw Kit 206 L/L1/L3/L4/407
4	6	4	/ 6				D2182B050	RUBBER CUSHION
8	12	8	/ 12			16	D2274	RADIUS BLOCK
2							D2435	19" X 16" BEARPAW
	2						D2432F	19" X 24" BEARPAW
		2					D2671	13" X 16" BEARPAW
			/ 2				D2672F	13" X 24" BEARPAW
4	6	4	/ 6				D2438	CLAMP
8	12	8	/ 12				D2529	WASHER
	6		/ 6				D2732-050	RUBBER CUSHION
						8	D3456-1	WASHER
					2		D3859-041	WEARPLATE
				2			D3860-041	WEARPLATE
						8	D4011-1	CLAMP, SHORT
						8	D4011-5	CLAMP, SHORT (OEM)
						8	D4012-1	CUSHION
						2	D4355-1	BEARPAW
						2	D4360-041	WEARPLATE ASSEMBLY
						8	AN4C11A	BOLT
8	12	8	/ 12	8	12		AN4-17A	BOLT
8	12	8	/ 12	8	12		AN4-20A	BOLT
						16	AN4C20A	BOLT
						16	AN4C21A	BOLT
16	24	16	/ 24	8	12	16	NAS1149D0463J	WASHER (OR AN960JD416)
8	12	8	/ 12	8	12		MS21042L4	NUT (OR MS21042-4)
						24	MS21043-4	NUT
2		2					QS200M44S	CLAMP